

Work Order ID 157845

Monday, February 27, 2017 3:53:24 PM

157845

Page 1

Item ID: D3284-007

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stud

Start Date: 2/28/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/3/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: 

Date: FEB 27 2017 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3284

Rev B

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 35442 BE AEROSPACE Order P/N: B80705-
1 Manufacture per B80705 Rev. B Certificate of Conformity is required2

FEB 28 2017

DAS
13
9-89

110

0.00

110

Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

2

MAR 01 2017

DAS
6
9-89

120

0.00

120

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Visually inspect parts for thread damage, fit and cad plating

2DAS
38
9-89

MAR 01 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

Work Order ID 157845

Monday, February 27, 2017 3:53:24 PM

157845

Page 2

Item ID: D3284-007 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Stud
Start Date: 2/28/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 3/3/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>Sto29</u>	0.00							
130									
Packaging	Memo	0.00				<u>2</u>		DAS 6	
Packaging								9-89	
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

17/3/2 

DAS
21
9-89 MAR 01 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, February 27, 2017 3:53:30 PM

Page 1

Work Order ID: 157845

157845

Parent Item: D3284-007

D3284-007

Parent Item Name: Stud

Start Date: 2/28/2017

Required Date: 3/3/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B04.10.21Added Step 4KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B80705-1		Purchased	No			110	Each	0.0000	1	2			

B80705-1

stud

MAR 01 2017

DAS
6
9-80

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐				

SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
D3284-009 BEARING	BHT P/N 47-140-252-5
D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708



NOTE:

FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/-003/-005/-007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH

MIN Ft_u = 90 Ksi

MIN Ft_y = 70 Ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK CENTER
 NO. 15784
 FEB 27 2017

RELEASED

2010 -03- 25

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. B	
MFG. APPR.	<i>[Signature]</i>	D3284 SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE SCALE	
DE APPR.	<i>[Signature]</i>	ADJUSTABLE ENGINE MOUNT NTS	
DATE	09.07.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Passion to Innovate.
Power to Deliver.

Page 1 of 1

Certificate of Compliance

Customer: Dart Aerospace Ltd.
Customer Order Number: P035442
Sales Order Number: 37535-1

Part Number: B80705-1
Drawing / Revision Level: B
Production Order: PR1400016027

Description: Stud, Female, Engine Mount
Quantity: 2
Serial / Batch No.: 14-3335

B/E Aerospace Limited hereby certifies that materials, work performed and quality meet the requirements stated on the Customer's Purchase Order(s) and/or drawing(s).

Notes / Comments:

Signature:

Name: Tim Sinclair

Date:

28 Feb 17

Form completed by: Jean Martin



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Power to Deliver.

AEROSPACE

B/E Aerospace Limited

25 Dunlop Avenue

R2X 2V2 Winnipeg

Canada

Tel : 204-783-5402

Fax : 204-783-5436

Packing Slip

Delivery No. : 7596
Delivery Date : 2017-02-28
SO No. : 37535
Your Reference : PO: 35442
Delivery Method : FEDEX
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention: Chantal Lavoie

1270 Aberdeen Street

Hawkesbury K6A 1K7

Canada

Item	Description Batch Number	Total		Qty		Delivery Date
		Ordered	Unit	Delivered		
B80705-1	STUD, FEMALE, ENGINE MOUNT 14-3335	2	EA	2		2017-02-28
Chantal Lavoie 613 632 9577 Ship Via: FedEx PRIORITY Acct#: 15179324-0 clavoie@dartaero.com COC						
Packages: 0 Gross Weight: 0.00 Net Weight:						

Ordered by: Dart Aerospace Ltd.

Attention: Chantal Lavoie

1270 Aberdeen Street

Hawkesbury K6A 1K7

Canada

Invoice to: Dart Aerospace Ltd.

0.00

Attention: Accounts

1270 Aberdeen Street

Hawkesbury K6A 1K7

Canada

Remarks

Certification Statement

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.

Signatory

Date:



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35442**

Purchase Order Date 2/28/2017

PO Print Date 2/28/2017

Page Number 1 of 1

Order From :

VU-ACS001

Ship To : DART AEROSPACE LTD

B/E AEROSPACE
25 DUNLOP AVENUE
WINNIPEG, MB R2X 2V2

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

FEB 28 2017

Contact Name

Vendor Phone 204-772-9922

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	B80705-1	stud	3/1/2017		2.00	\$96.00	\$192.00
			Yes		Each		
			3/1/2017				

AS PER DWG D3284 REV. B
B157845

Line Total: \$192.00

2	71401-45	PROCUREMENT QUALITY CLAUSES	3/1/2017		1.00	\$0.00	\$0.00
			No				
			3/1/2017				

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

MAR 01 2017

DAS
6
2-28

Line Total: \$0.00

PO Total: \$192.00

DAS
38
9-89

CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 2/28/2017



Passion to Innovate.
Power to Deliver.

B/E Aerospace Limited

25 Dunlop Avenue
R2X 2V2 Winnipeg
Canada
Tel : 204-783-5402
Fax : 204-783-5436

Packing Slip

Delivery No. : 7596
Delivery Date : 2017-02-28
SO No. : 37535
Your Reference : PO: 35442
Delivery Method : FEDEX
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention: Chantal Lavoie
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Item	Description Batch Number	Total		Qty		Delivery Date
		Ordered	Unit	Delivered		
B80705-1	STUD, FEMALE, ENGINE MOUNT 14-3335	2	EA	2		2017-02-28
Chantal Lavoie 613 632 9577 Ship Via: FedEx PRIORITY Acct#: 15179324-0 clavoie@dartaero.com COC MAR 01 2017 OAS 6 7-85						
Packages: 0		Gross Weight: 0.00			Net Weight:	

Ordered by: Dart Aerospace Ltd.
Attention: Chantal Lavoie
1270 Aberdeen Street
Hawkesbury K6A 1K7
Canada

Invoice to: Dart Aerospace Ltd.
Attention: Accounts
1270 Aberdeen Street
Hawkesbury K6A 1K7
Canada

0.00

Remarks

OAS
38
3-89

Certification Statement:

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.